

Claims

1. A method of producing a grid for a battery electrode plate wherein the grid is formed from a sheet by means of a rotary expander which is equipped with a disk cutter cluster with an edge disk cutter,
5 characterized in that there is a notch that penetrates the outer periphery of said edge disk cutter in the thickness direction of the said edge disk cutter.
2. The method of producing a grid for a battery electrode plate according to Claim 1, characterized in that a ridge of said edge disk cutter protrudes by 30%
10 or greater of the thickness of said sheet from a reference plane of said disk cutter cluster toward the side of a disk cutter roll opposed to a disk cutter roll equipped with said edge disk cutter.
3. The method of producing a grid for a battery electrode plate according to Claim 2 characterized in that a ridge of said edge disk cutter protrudes by 70%
15 or greater of the thickness of said sheet from a reference plane of said disk cutter cluster toward the side of a disk cutter roll opposed to a disk cutter roll equipped with said edge disk cutter.
4. The method of producing a grid for a battery electrode plate according to Claim 1 characterized in that the height of protrusion of a ridge of said edge disk
20 cutter from a reference plane of said disk cutter cluster toward the side of a disk cutter roll opposed to a disk cutter roll equipped with said edge disk cutter is 110% or less of the thickness of said sheet.
5. The method of producing a grid for a battery electrode plate according to Claim 1 characterized in that a bottom part of said notch is positioned on the
25 side of a disk cutter roll equipped with said edge disk cutter against a reference plane of said disk cutter cluster.
6. The method of producing a grid for a battery electrode plate according to Claim 1 characterized in that an inclined plane is formed that contacts with a
30 ridge of said edge disk cutter at least at a part of contact with said notch and approaches a rotation shaft of the edge disk cutter as it proceeds toward the outside of said disk cutter cluster along said rotation shaft.
7. The method of producing a grid for a battery electrode plate according to

Claim 6 characterized in that a peripheral side face exists at said outer periphery.

8. A method of producing a battery characterized by using a grid for a battery electrode plate produced in accordance with the production method according to Claim 1.
- 5